

Date: Tuesday, 04/07/2006 12:36:11 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECK PLATE,FWD ,350 LITTER KIT
Job Number : 27737	
Estimate Number : 11104	
P.O. Number : N/A	Part Number : D2364
This Issue : 04/07/2006 S.O. No. : N/A	Drawing Number : D2364 REV.F
Prsht Rev. : NC	Project Number : N/A
First Issue : 28/06/2006 Type : MACHINED PARTS	Drawing Revision : F
Previous Run :	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 22/07/2006 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : EST. REV. E 00.06.26 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s)
 2024-T3 .063 Aluminum sheet
 (M2024T3S063)
 Batch: M101022

[Signature] 06 07 11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

[Signature] 06 07 11

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 06 07 12

(8)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

[Signature] 06-07-20 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

[Signature] 06/07/28

(8)

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING / Acid etch & Alodine
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

[Signature] 06/07/31
[Signature] 06/07/31 (8)

(8)

Date: Tuesday, 04/07/2006 12:36:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PV 4/8/01 (8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST173*

LB 06/08/01 (8)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/02 (8)

Job Completion



C 206/08/01

Date: Wednesday, 6/28/2006 4:17:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECK PLATE,FWD ,350 LITTER KIT
Job Number : 27737	
Estimate Number : 11104	
P.O. Number :	Part Number : D2364
This Issue : 6/28/2006 S.O. No. :	Drawing Number : D2364 REV.F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : F
Previous Run :	Material :
Written By : <u> </u>	Due Date : 7/22/2006 Qty: 8 Um: Each
Checked & Approved By : <u> </u>	
Comment : EST. REV. E 00.06.26 Removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s)
 2024-T3 .063 Aluminum sheet
 (M2024T3S063)
 Batch: M101022

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 13.70" x 6.80" +0.045/-0.000

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D2364 as per Folio D2364 and Dwg D2364

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:17:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 06/08/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 27737
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.625	✓		VERN	
Ø0.171	+0.005/-0.000	0.171	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
11.242	+/-0.010	11.245	✓		Height Gauge	
3.031	+/-0.010	3.037	✓		VERN	
1.903	+/-0.010	1.906	✓		VERN	
1.128	+/-0.010	1.130	✓		VERN	
0.354	+/-0.010	0.353	✓		VERN	
1.340	+/-0.005	1.343	✓		VERN	
2.326	+/-0.010	2.327	✓		VERN	
3.312	+/-0.010	3.313	✓		VERN	
4.298	+/-0.010	4.299	✓		VERN	
5.284	+/-0.010	5.284	✓		VERN	
6.151	+/-0.010	6.151	✓		VERN	
6.270	+/-0.010	6.270	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
3.031	+/-0.010	3.037	✓		VERN	
Ø0.656	+0.005/-0.000	0.656	✓		VERN	
5.003	+/-0.010	5.003	✓		VERN	
4.605	+/-0.010	4.607	✓		VERN	
1.776	+/-0.010	1.779	✓		VERN	
0.980	+/-0.010	0.978	✓		VERN	
4.487	+/-0.010	4.492	✓		VERN	
7.192	+/-0.010	7.198	✓		VERN	
7.597	+/-0.010	7.573	✓		VERN	
7.942	+/-0.010	7.948	✓		VERN	
Ø0.191	+0.005/-0.000	0.191	✓		VERN	
Ø0.197	+0.005/-0.000	0.197	✓		VERN	
11.145	+/-0.010	11.149	✓		VERN	
12.181	+/-0.010	12.183	✓		Height Gauge	
11.378	+/-0.010	11.375	✓		Height Gauge	
11.776	+/-0.010	11.780	✓		Height Gauge	
12.173	+/-0.010	12.176	✓		Height Gauge	
4.690	+/-0.010	4.693	✓		Height Gauge	
0.250	+0.005/-0.000	0.250	✓		VERN	
3.1413.144	+/-0.010	3.151	✓		VERN	
0.171	+0.005/-0.000	0.171	✓		VERN	

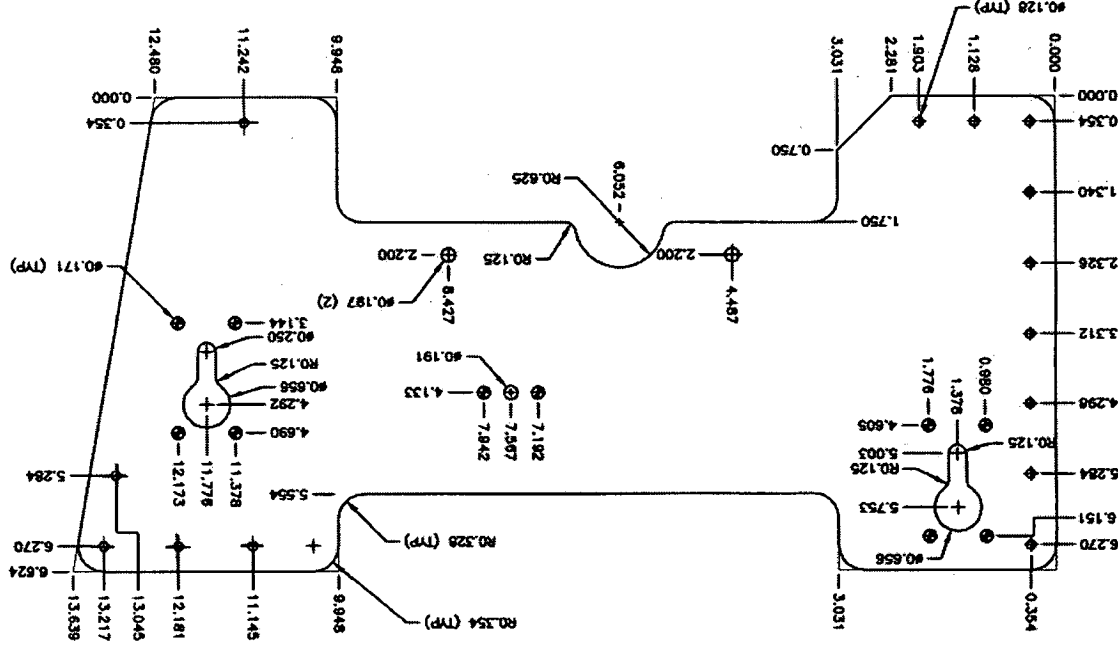
Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 06/07/12	Date: 06/07/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	[Signature]



RELEASED
98/06/22 K6

COUNTER SINK HOLES:
 C'SINK Ø0.225 x 100°
 C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (00-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE

WORK ORDER
NO. 27737

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